

Date: Monday, 1/14/2008 2:37:00 PM
 Kim Johnston

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 36747	
Estimate Number : 10255	
P.O. Number :	Part Number : D22301
This Issue : 1/14/2008 S.O. No. :	Drawing Number : D2230 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 36102	Material :
Written By : <i>[Signature]</i>	Due Date : 2/15/2008 Qty: 60 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 14.3430 f(s)

Lug Extrusion D2423 Extrusion

Batch: *33310*

c20810115

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch: _____

cut at 0.82"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

Issue PD 5448

Machine per ~~Edto~~ drag D2230 Rev. F

c20810115

(200)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ensure 1 of C attached 1/14/08 (60)

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

Inspect level 5

1/14/08

counts

(160)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 36747

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Job 8-1-30 (60)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/31 + 60

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

08-01-31

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/01/31 (60)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

SI 476

08/02/05 (x60)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/06

Job Completion



2008/2/05 (60)

W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

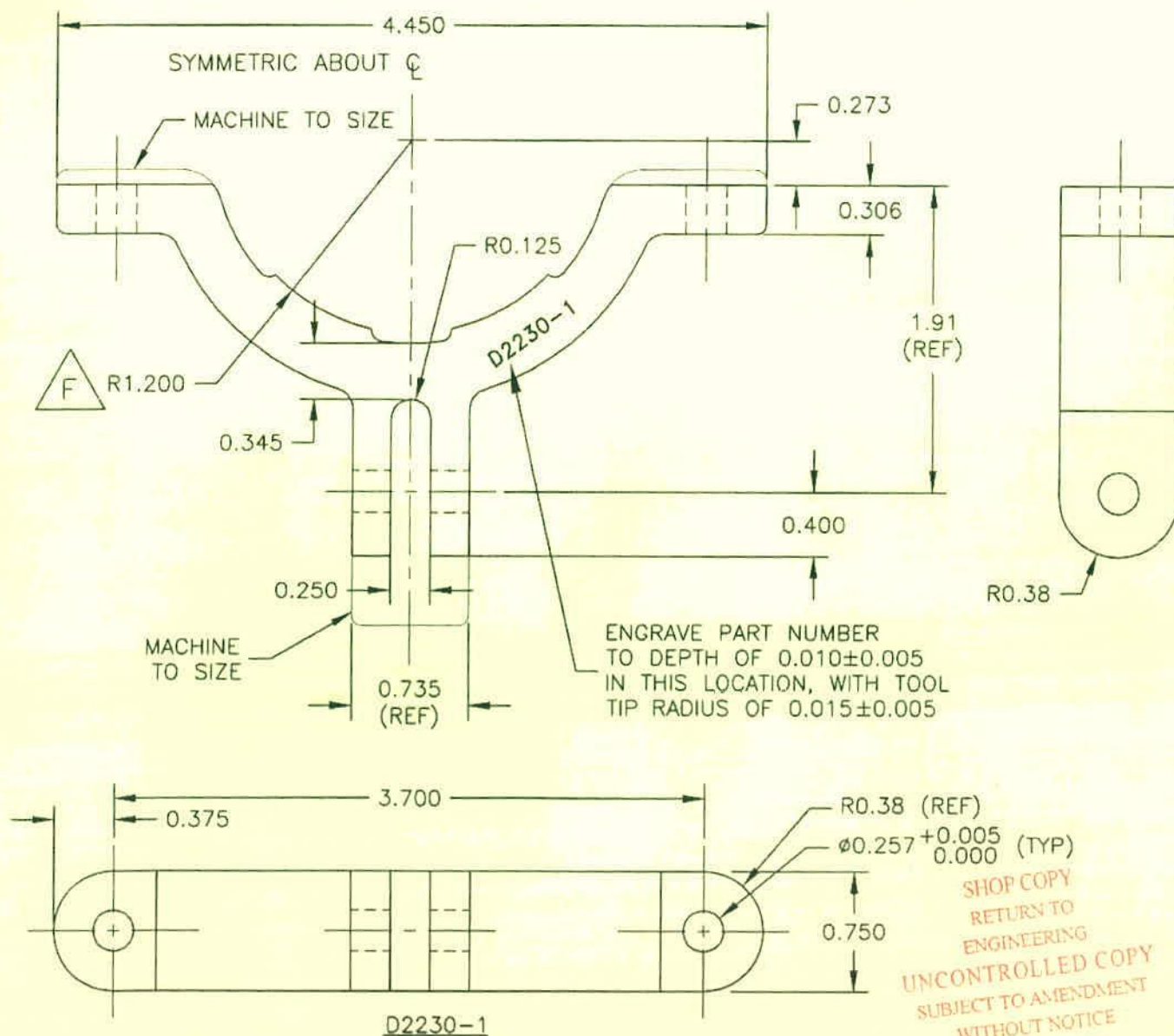
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. F
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2230	SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE	1:1
C	94.03.30	RE-DESIGN			
D	95.01.04	RE-DESIGN			
E	95.01.04	RE-DESIGN			
F	99.12.13	REDESIGN; R1.200 WAS R1.100			

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

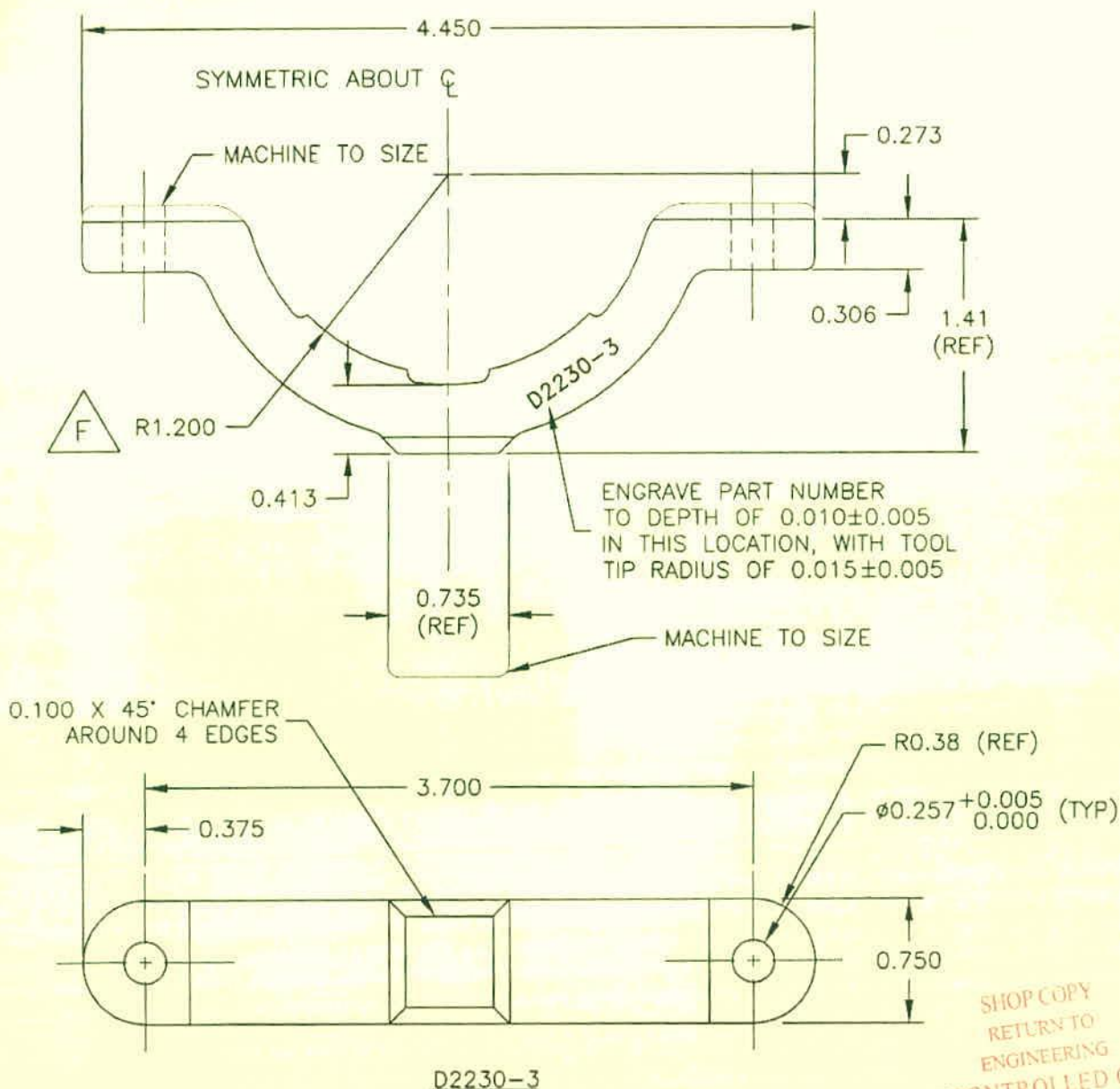
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36747

This image shows a blank, aged, cream-colored page, likely an endpaper or flyleaf of a book. The paper has a slightly textured appearance with some minor creases and discoloration, characteristic of old paper. A dark binding edge is visible on the right side.



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36747

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

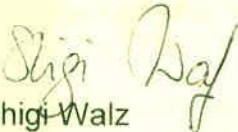
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D2230-1	Lug B36747	P5448

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, January 29, 2008

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853

THE HISTORY OF THE
CITY OF NEW-YORK
FROM THE FIRST SETTLEMENT
TO THE PRESENT TIME
IN TWO VOLUMES
BY J. C. HEATON
NEW-YORK: PUBLISHED BY
J. C. HEATON, 101 NASSAU ST.
1853